

Date: Thursday, 3/2/2006 3:08:12 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 26039  
 Estimate Number : 10280  
 P.O. Number : N/A Part Number : D3137043  
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D3137 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
 Previous Run : 25557C Material : N/A  
 Due Date : 3/26/2006 Qty: 4 Um: Each  
 Written By : SRL Comment Below  
 Checked & Approved By : JA 06.03.02  
 Comment : Est Rev:A 04.02.18 New issue KJ/DS

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B0500X02000 17-4 SS Bar



Comment: Qty.: 0.4875 f(s)/Unit Total: 1.9501 f(s)  
 Material: 17-4 SS Bar per AMS 5604/5643  
 (M17-4-B0.500x02.000)  
 Identify for D3137-7  
 Batch: M19542

JL 06.03.18

2.0 BAND SAW BAND SAW



Comment: BAND SAW 6.500"  
 Cut blanks: (1.000" x 2.000") 5.570" long

JL 06.03.18

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7  
 2-Deburr  
 3-Scribe batch number

JL 06.03.19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06.03.19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/2/2006 3:08:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26039

Part Number: D3137043

Job Number:



~~B 26039x4~~ B 26039x4 (2) 06/06/01

Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/03/19

4

6.0

D31373

Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3137-3

GUIDE

B 26888

7.0

D31375

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3137-5

Washer

B 27246

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS24694-s101

Screw

M18431

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3137-043 as per Dwg D3137

M.F. 06-06-01

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/01

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 410

PC 06/06/01 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 20/06/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/2/2006 3:08:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26039

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*SP* 06/06/01 (7)

Job Completion



*cl de-de-s1*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>
<b>Description:</b> Bracket		<b>Part Number:</b> D3137-7
<b>Inspection Dwg:</b> D3137	<b>Rev:</b> C2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	.434	✓			
0.615	+/-0.010	.625	✓			
0.200	+/-0.010	.203	✓			
0.380	+/-0.010	.390	✓			
0.262	+/-0.010	.265	✓			
Ø0.500	+0.005/-0.000	.503	✓			
0.79	+/-0.030	.790	✓			
2.79	+/-0.030	2.775	✓			
Ø0.560	+0.005/-0.000	.565	✓			
0.595	+/-0.010	.596	✓			
0.950	+/-0.010	.949	✓			
0.605	+/-0.010	.605	✓			
1.880	+/-0.010	1.881	✓			
2.48	+/-0.030	2.479	✓			
4.975	+/-0.010	4.975	✓			
5.41	+/-0.030	5.412	✓			
0.032	+/-0.010	.032	✓			
0.063	+/-0.010	.063	✓			
R0.062	+/-0.010	R.062	✓			
0.162	+/-0.010	.165	✓			

<b>Measured by:</b> JL	<b>Audited by:</b> mk	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06-03-18	<b>Date:</b> 06/03/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	

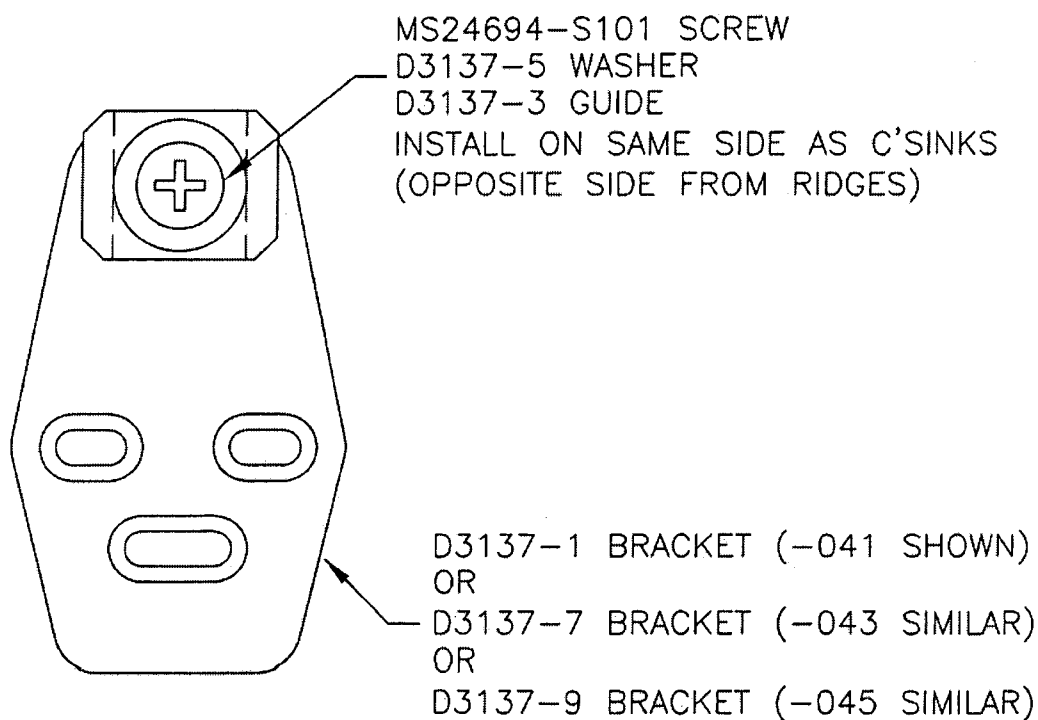
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 06-03-18



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CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09



D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)  
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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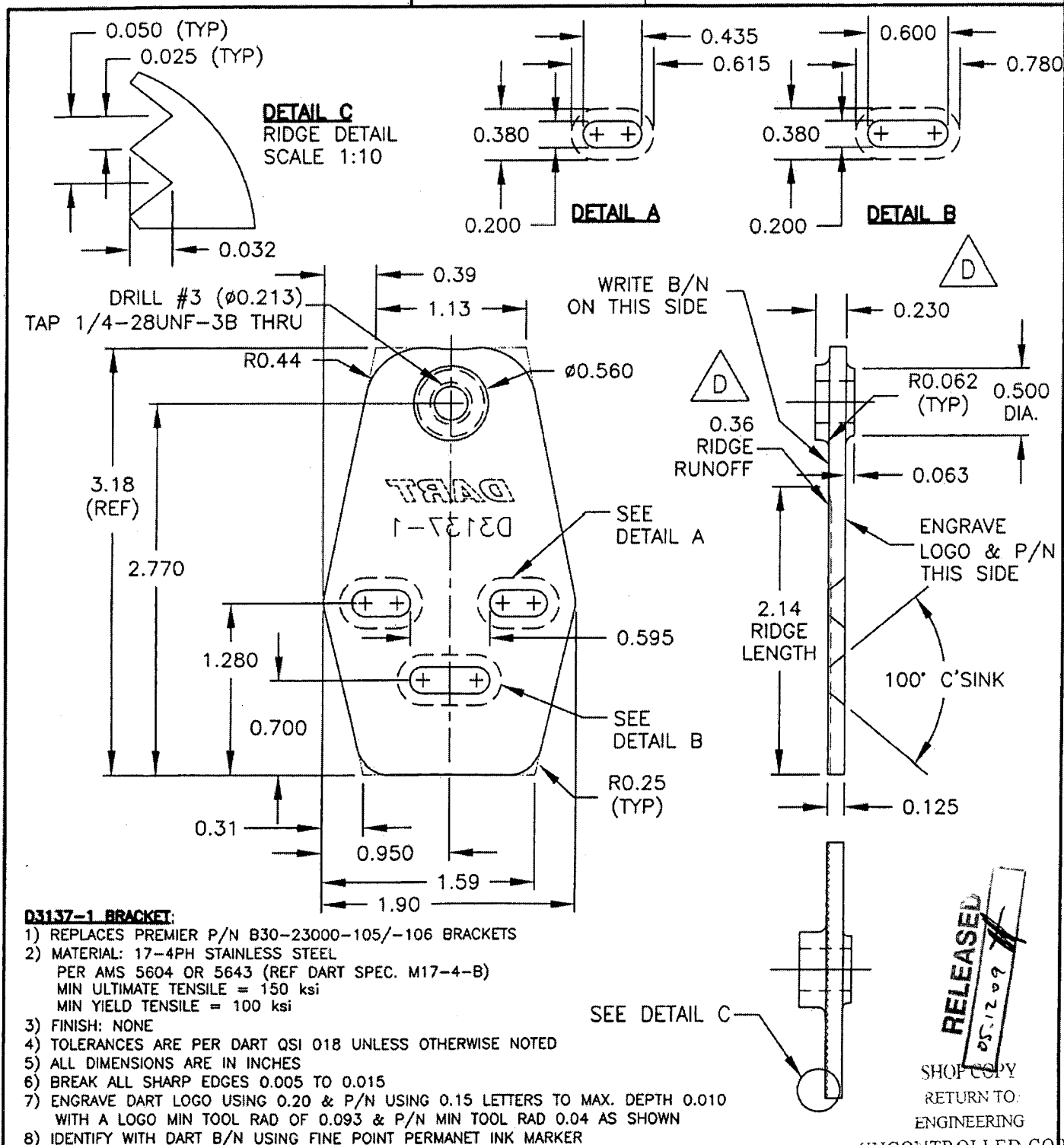
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DATE <b>05.11.23</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



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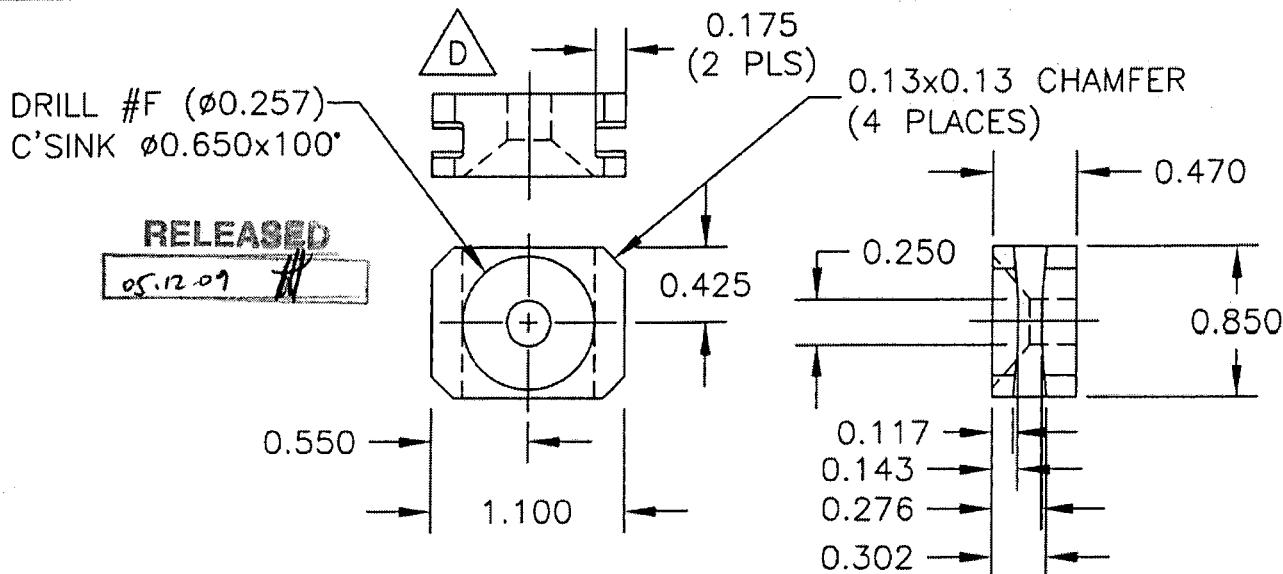
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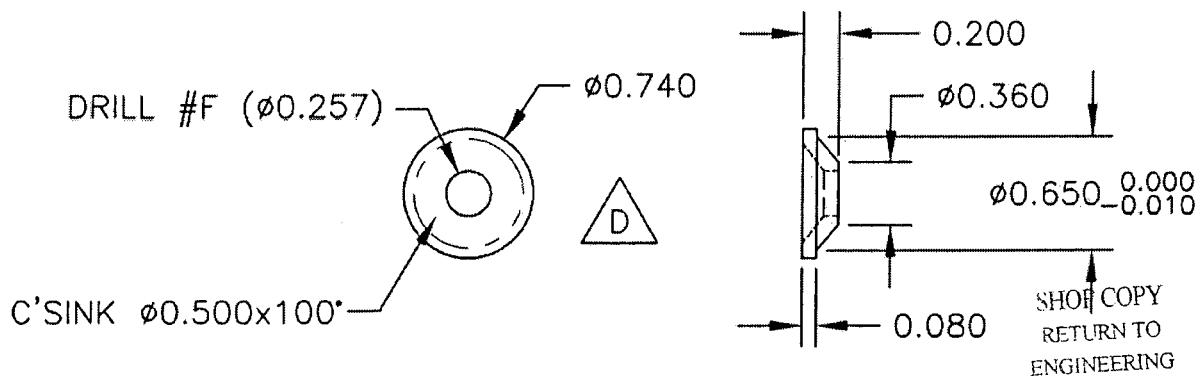


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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1



#### D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015





#### D3137-5 WASHER

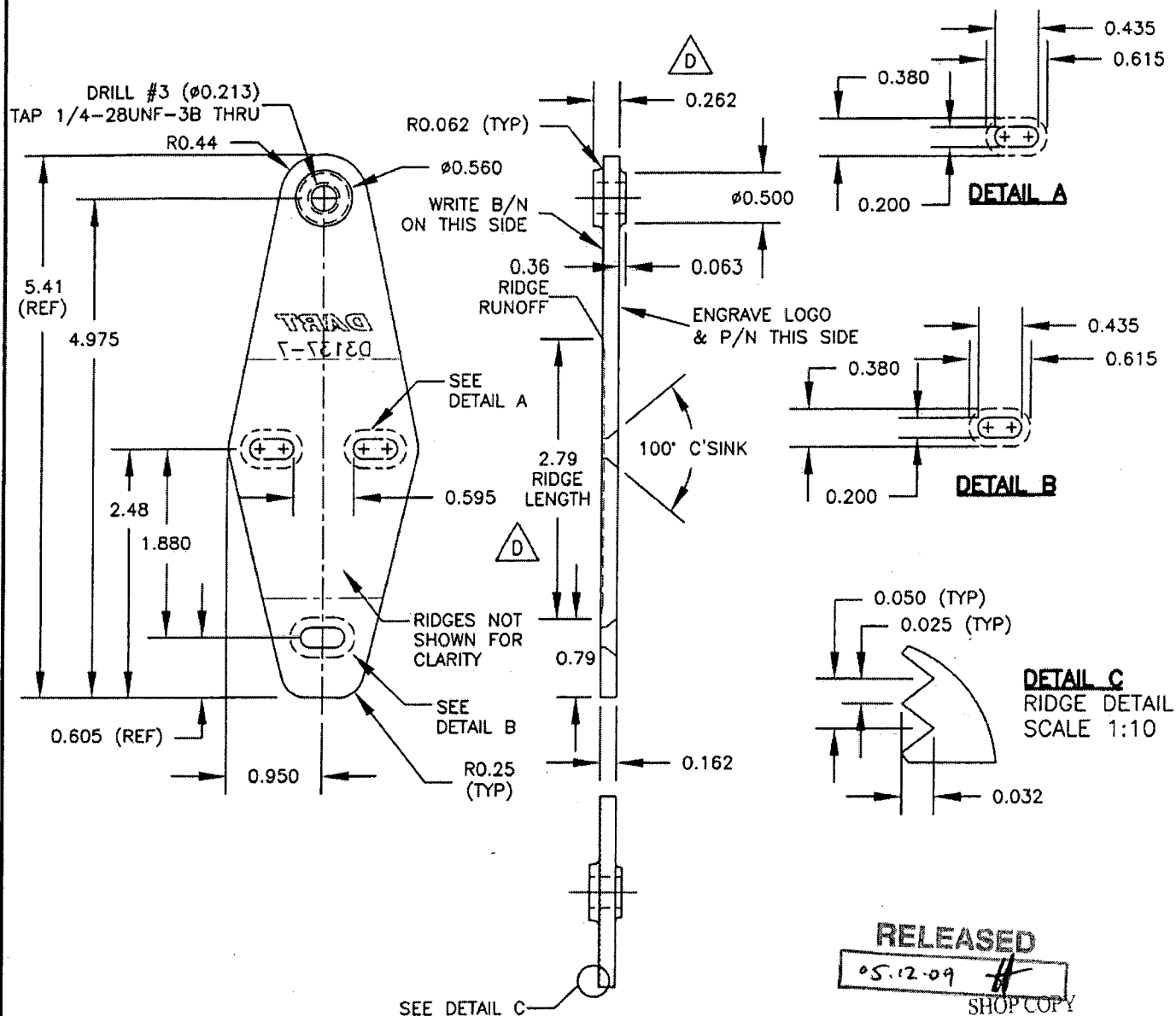
- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 2:3



**D3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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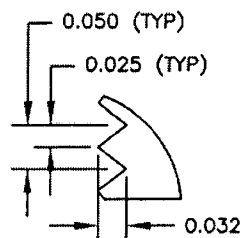
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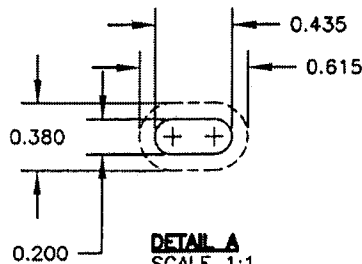
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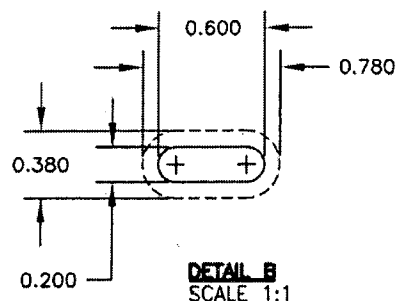
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:2



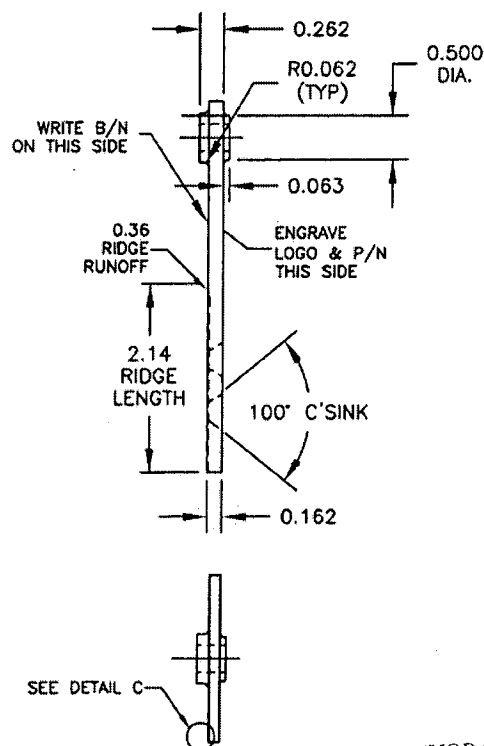
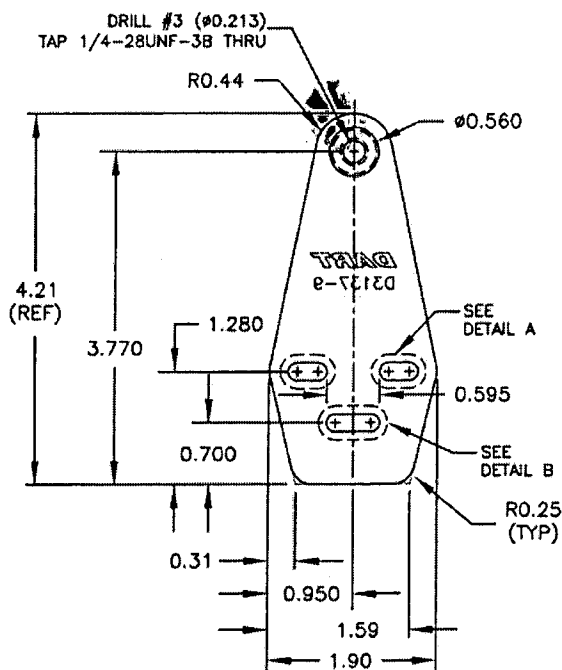
**DETAIL C**  
RIDGE DETAIL  
SCALE 1:20



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1



**D3137-2 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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